



Dart Aerospace Ltd.
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6

D350-748-143TRN
Job Sheet 173666



Part No: D350-748-143TRN

Job Qty: 1 ea

Part Name: Ss Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A NEW ISSUE - PRELIM - LL 12.05.08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Crosstubes-1		M.D. PMP
100	Mori Seiki	1 pcs		4/17/18	7.06	2.81	Mori Seiki TL-40		M.D. PMP
110	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		M.D. PMP
120	Mori Seiki	1 pcs		4/17/18	0.00	2.81	Mori Seiki TL-40		M.D. PMP
130	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		M.D. PMP
140	QC	1 pcs		4/17/18	0.00	0.00	QC8		GP 18-06-20
150	Crosstubes	1 pcs		4/18/18	0.00	0.97	Crosstubes-2		GP 18-06-23
190	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		GP 18-06-27
200	QC21-SA	1 Ea		4/18/18	0.00	0.00	QC21		GP 18-06-27

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-141 on both ends. 2-Face both sides of Descriptions: tube. 3- Turn program 02000 section on both side as per folio FB467. 4- Turn program 03000 section on both side as per folio FB467. 5- Blend transsition lines only with belt sander 60 grit Dwg rev: A

120 - 1- Turn program 04000 section on both side as per folio FB467. 2- Blend transsition lines only with belt sander 60 grit 3- Scribe part # as per Dwg D350-748-143

130 - PERFORME ULTRASONIC MEASURMENT

150 - 1-Grind machining marks

190 - Identify and stock in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6021-125	Crosstube Material - 17-4Ph SS	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6021-125	1	71	0

B127272

Part Specifications

Specifications could not be found.

Plex 3/6/18 12:15 PM Dart.Gagnon.Michelle



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Container No: S081386



Part: D350-748-143TRN

Job No: 173666

Serial No/Batch: S081386

Revision:

Inspector:

Exp Date:

Instructions:

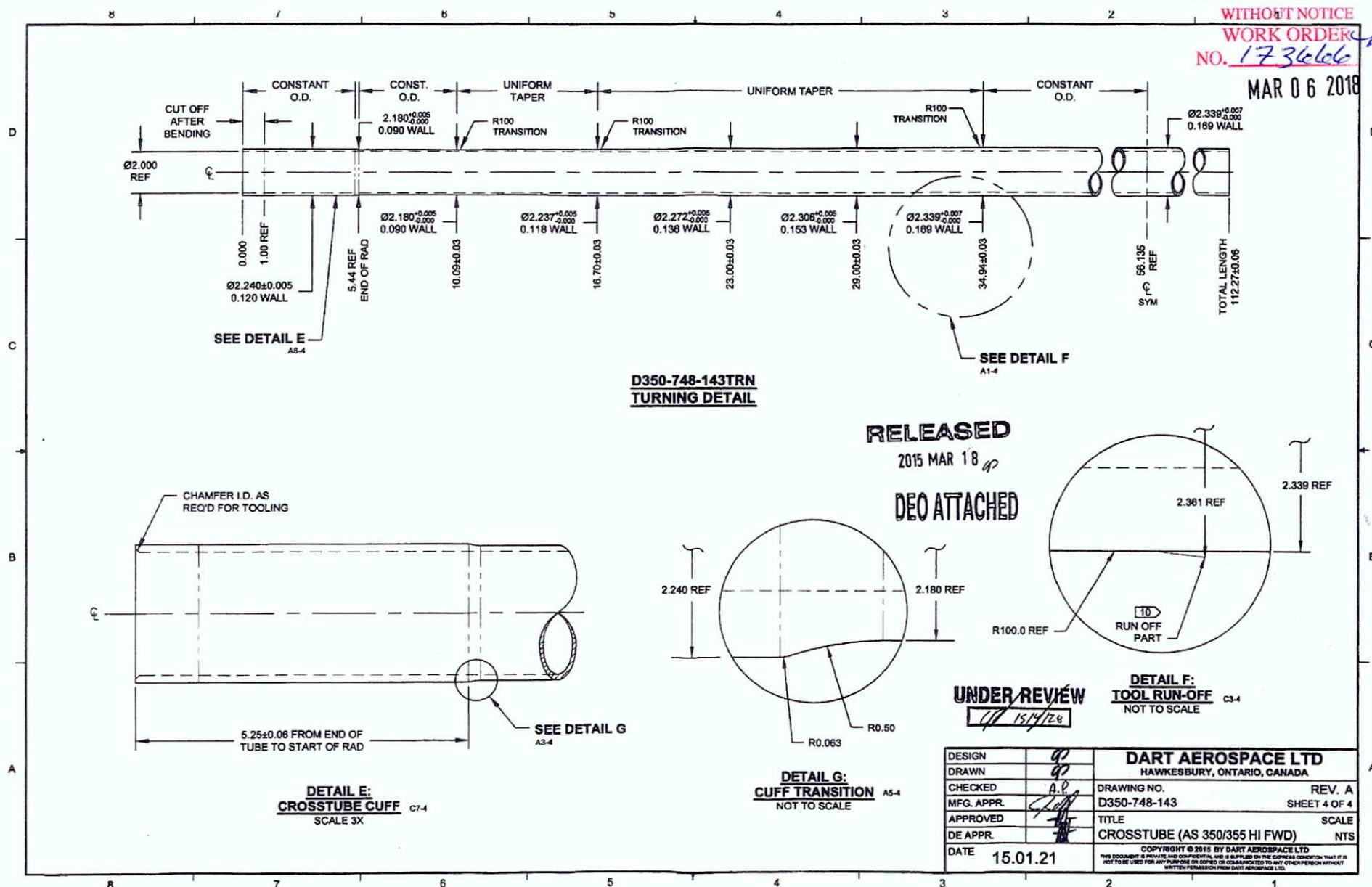
Date: 06/15/18

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WITHOUT NOTICE

WORK ORDER
NO. 173666

MAR 06 2018



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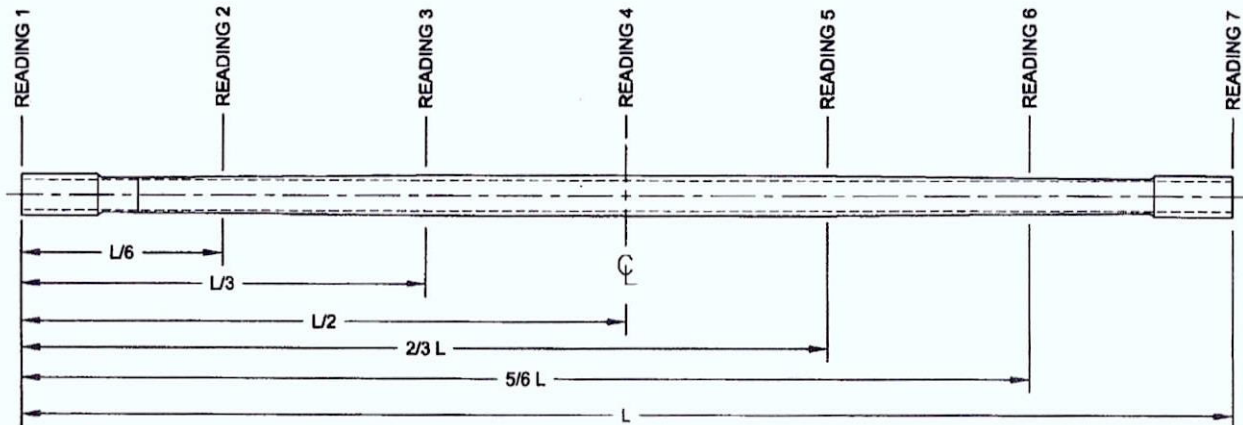
DART AEROSPACE LTD	Work Order: 173666
Description: Crosstube Assembly (AS350/355 High Fwd SS)	Part Number: D350-748-143
Inspection Dwg: D350-748-143 Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005	2.245	✓		BLM 3" 04	
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.237	+0.005/-0.000	2.242	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.306	+0.005/-0.000	2.311	✓			
	2.339	+0.007/-0.000	2.346	✓		Vern 08	
	2.339	+0.007/-0.000	2.345	✓		Vern 08	
	0.062	+/-0.010	.062	✓		RG	
	5.25	+/-0.060	5.250	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.50	+/-0.030	.500	✓		RG	
SIDE B	2.240	+/-0.005	2.245	✓		BLM 3" 04	
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.237	+0.005/-0.000	2.2415	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.306	+0.005/-0.000	2.311	✓			
	2.339	+0.007/-0.000	2.3455	✓		Vern 08	
	2.339	+0.007/-0.000	2.3455	✓		Vern 08	
	0.062	+/-0.010	.062	✓		RG	
	5.25	+/-0.060	5.249	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.50	+/-0.030	.500	✓		RG	
	112.27	+/-0.060	112.27	✓		Tape	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	.144	.133	.140	.137	.011	0.030"
READING 2 L = 18.71	.145	.149	.141	.139	.010	
READING 3 L = 37.42	.185	.191	.195	.191	.010	
READING 4 L = 56.14	.188	.189	.189	.189	.001	
READING 5 L = 74.85	.192	.193	.190	.187	.006	
READING 6 L = 93.56	.143	.143	.137	.135	.008	
READING 7 L = 112.27	.133	.136	.136	.141	.008	

Calibration Result

Actual Block Thickness: 100-300

Sitiescan 250 Measured Thickness: 100-200

Measured by: M.D. [Signature]
Date: 2018-06-14

Audited by: G.P. [Signature] 18-06-20
Date:

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue (P/O D350-748-103)	KJ [Signature]	[Signature]